

ASAP

Work Order ID 58204

Thursday, April 29, 2010 10:36:36 AM

Page 1

Item ID: D3637-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket

Start Date: 4/29/2010 Start Qty: 10.00

Required Date: 5/14/2010 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Run Start

Approvals:

Process Plan: *mf*

Date: 10-4-29 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3637

Rev B

100



Waterjet

FLOW CNC Waterjet

7024, 050

FLOW WATER JET

Memo

1-Cut as per Dwg D3637 Dwg Rev: *B* Prog Rev: *B* 2-
Deburr if necessary

HB 10-5-10



110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

HB 10-5-10

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

Solo 10

counted
(120)

Work Order ID 58204

Thursday, April 29, 2010 10:36:36 AM

Page 2

Item ID: D3637-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket

Start Date: 4/29/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 5/14/2010 Req'd Qty: 10.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

NC BRAKE

0.00



Brake NC

Memo

0.00

Brake NC

Form as per Dwg D3637

Sp 10/05/10

3

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sp 10/05/10

+3

150

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1- drill holes as per dwg using DT8979 2- c'sink holes as per dwg. 3-deburr

= 7 m. l 10/05/10

3X

Work Order ID 58204

Thursday, April 29, 2010 10:36:36 AM



Page 3

Item ID: D3637-3

Revision ID:

Item Name: Bracket

Start Date: 4/29/2010

Start Qty: 10.00

Required Date: 5/14/2010

Req'd Qty: 10.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Sw 10/10

0.00

Memo

x3

170



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

pl 10/05/10

0.00

Memo

x3 0

180



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

Memo

3 pl 10-5-10

Work Order ID 58204

Thursday, April 29, 2010 10:36:36 AM



Page 4

Item ID: D3637-3

Accept



Setup Start

Revision ID:

Item Name: Bracket

Stop

Start Date: 4/29/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 5/14/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PDD 58485

0.00

Packaging

LC 10/10

(3)

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/10

MF

10-5-10

Picklist Print

Thursday, April 29, 2010 10:36:35 AM

Work Order ID: 58204



Parent Item: D3637-3



Parent Item Name: Bracket

Start Date: 4/29/2010

Required Date: 5/14/2010

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC
IPP Rev:B change to REV.B as per dwg 08-02-11 DD verified by:EC

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	43.3947	0.134	2.7		
2024-T3 .050 sheet												



B10-5-10

Location

Loc Qty

Loc Code

MAT22

43.3947

111381

32

112291

11

113189

0.3947

112291

FIRST ARTICLE INSPECTION CHECKLIST

8 7 6 5 4 3 2 1

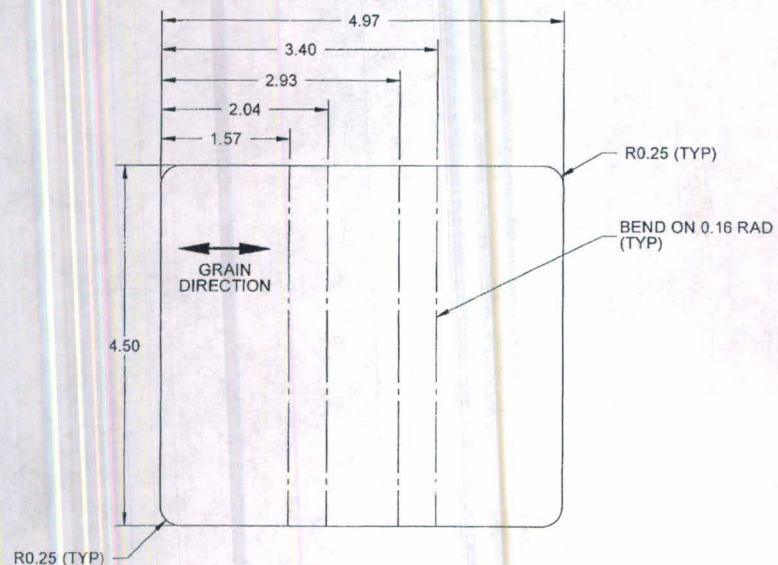
D

C

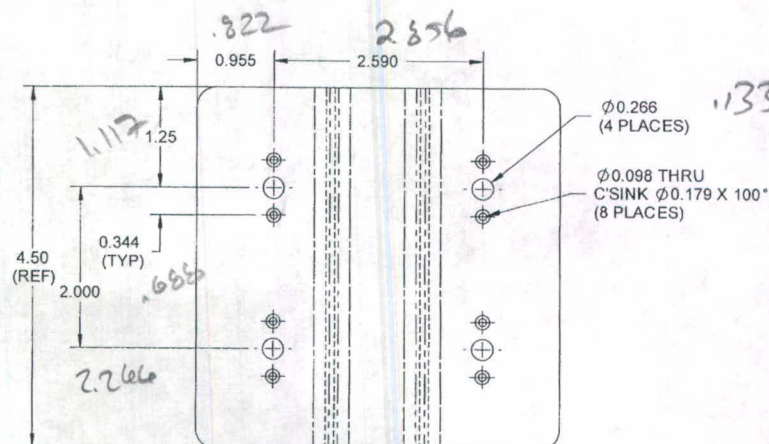
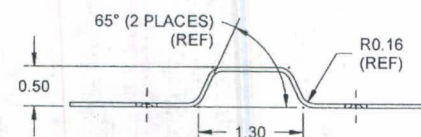
B

A

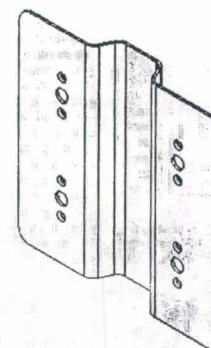
#58204



D3637-3F FLAT PATTERN



D3637-3 BRACKET
(WAS GENEVA P/N G10609-1)



D3637-3 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

DESIGN	TS	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PE	DRAWING NO.	REV. B
MFG. APPR.	ED	D3637	SHEET 3 OF 3
APPROVED	IN	TITLE	SCALE
DE APPR.	TH	BRACKET	2:3
DATE	07.12.18	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1

